

Date:
User:Tuesday, 13/01/2009 9:22:21 AM
Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REAR OVERHEAD CENTER
Job Number : 44720	
Estimate Number : 13591	
P.O. Number :	Part Number : D38233
This Issue : 13/01/2009 S.O. No. :	Drawing Number : D38233 UNDER REVIEW <i>OK 09.01.14 upto step 9</i>
Prsht Rev. : NC	Project Number : IN0002
First Issue : / / Type : R&D THERMOFORMING	Drawing Revision : A UNDER REVIEW
Previous Run : 43181	Material : MKYD6185S080P362015
Written By :	Due Date : 20/01/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 09.01.13</u>	
Comment : Est. A New Issue 08/09/17 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	~ MKYD6185S080P362015	6185 KYDEX .080"
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M109703



Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s)
6185 Kydex .080"

BB 09/01/14

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/01/14

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/01/14

X2 (+2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-3 and folio (FTA 9110 Prototype) using tool DT 9110

Dwg. Rev. AFolio Rev. A

BB 09/01/14

X2 (+2)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/01/14 X2 (+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD CENTER

Job Number: 44720

Part Number: D38233

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09.01.16

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

PTD
BB 09/02/17 (X1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/02/17 (X1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.04.15
ENGINEERING
APPROVAL

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



09.04.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.01.14	7	DIMENSION "0.50 MIN" IS "0.31 MIN" IS N/A PA 09.04.15						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 44720
Description: Remr overhead center	Part Number: D3823-3
Inspection Dwg: D3823 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				None specified
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: J Date: 09-02-23

TRIMMING SECTION

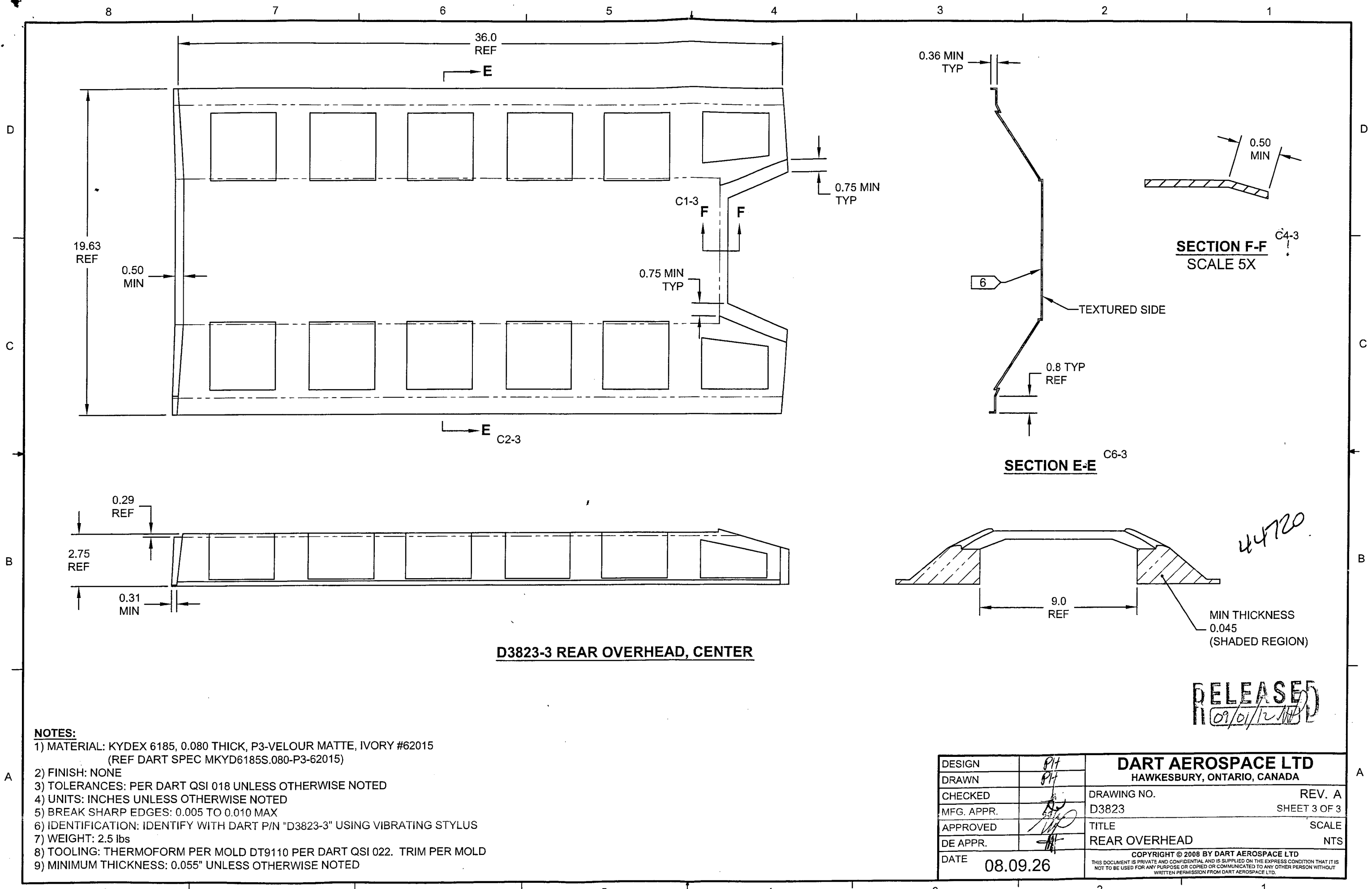
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.0 (Ref)		36.0	✓		Tape	
19.63 (Ref)		19.63	✓		Tape	
0.50	min.	0.55	✓		vern	
0.75 (typ)	min	0.82	✓		vern	
0.29 (Ref)		0.420	✓			(Revise?? dim. 0.045)
2.75 (Ref)		2.75	✓		tape	Rev. B dwg attached
0.31	min.	0.32	✓		vern	Wh
0.36	min	0.36	✓		vern	
0.8 Typ (Ref)		0.8	✓		vern	
9.0 (Ref)		9.0	✓		Tape	
0.5 (F-F)	min	0.5	✓		vern.	
0.045	min mat thick	0.051	✓		mic.	

Measured by: J Date: 09-02-23

Audited by: DT Date: 02/04/15

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3823-3 REAR OVERHEAD, CENTER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-3" USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

RELEASED
09/01/12

DESIGN	P14	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	P14		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3823	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	08.09.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

